



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB23006783
Job Sheet 173202



Part No: RB23006783

Job Qty: 4 ea

Part Name: Adapter, Torque Turbine Attach Upper Nut



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/27/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: Dwg. RB23006783 Rev.A IPP Rev.A 18.01.19 New Issue JFS Verify by: DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	4 Ea		3/15/18	0.00	0.00	Start Up Large Fab-7		EL
100	Large Fab	4 pcs		3/16/18	0.08	0.40	Large Fab 8		EL
110	QC	4 pcs		3/16/18	0.00	0.00	QC9		CPC
120	QC	4 pcs		3/16/18	0.00	0.00	QC5		CPC
130	Packaging	4 pcs		3/16/18	0.00	0.00	Packaging3-2		SP
140	QC21-FG	4 Ea		3/16/18	0.00	0.00	QC21		SP

Part Op 100 - 1- Manufacture RB23006783-1 as per dwg. 2- Bead blast area to be weld. 3- Weld square drive as per dwg. 4-
Descriptions: Polish weld S.S. Rod Batch: _____
130 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
FS101	Snap-On,Shallow Socket	4 Ea (1 ea)	90-Start up Operation	
XS1214	Snap-On 3/8-7/16 Short, 10° Offset Bex Wrench	4 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	FS101	4	7	0
	XS1214	4	7	0

Part Specifications

Specifications could not be found.



Container No: S045929



Part: RB23006783

Job No: 173202

Serial No/Batch: S045929

Revision: RB23006783

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

3 8:20 AM Dart.lajeunesse.marie

Date: 02/27/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

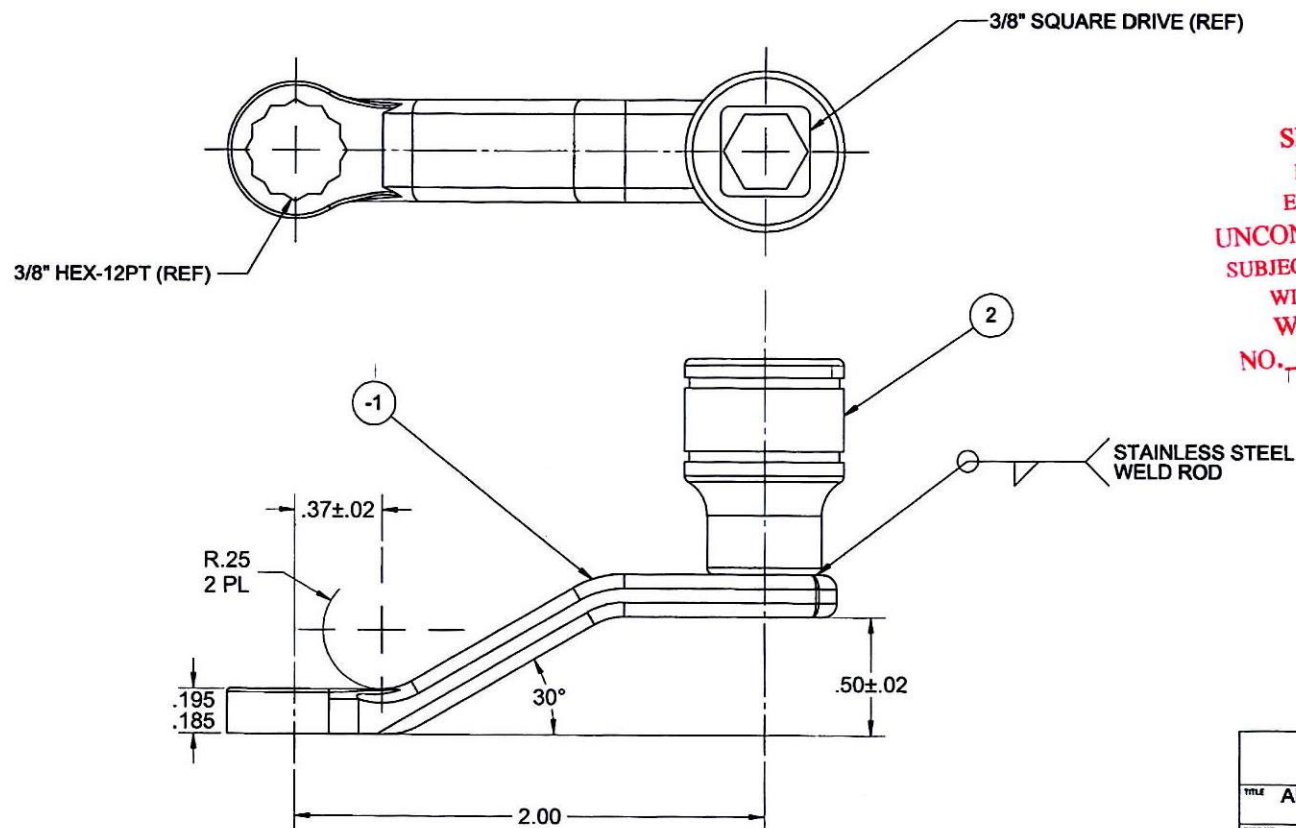
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

ITEM #	QTY	PART #	DESCRIPTION	PG
-1	1	RB23006783-1	WRENCH, MODIFIED	2
2	1	SNAP-ON FS101	SOCKET, 3/8" DRIVE, 5/16" SOCKET, SHALLOW	-

3		2		1	
REV.	DESCRIPTION		DATE	BY	APPROVED
A	NEW ISSUE <i>ECN 17-094</i>		17.09.18	SAC	WM



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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173202 MWS
1802-27

- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) HEAT TREAT: N/A
4) SPEC: N/A
5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
6) IDENTIFICATION: N/A

RB23006783 ADAPTER - TORQUE TURBINE ATTACH NUT, UPPER

DART AEROSPACE Newbury, Ontario, Canada	
TITLE: ADAPTER - TORQUE TURBINE ATTACH NUT, UPPER	
DWG NO.: RB23006783	REV: A
DESIGN BY: SAC 18/09/2017	CHECK: WM 09/21/2017
DRAWN BY: SAC 09/19/2017	DATE: 09/28/2017
CHECKED: WM 09/21/2017	DATE: 10/03/2017
MFG. APPR: DP 09/28/2017	DATE: 9/19/2017
APPROVED: WM 10/03/2017	DATE: 9/19/2017
SCALE: NTS	WEIGHT: N/A
SHEET 1 OF 2	
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DQA: _____ Date: _____



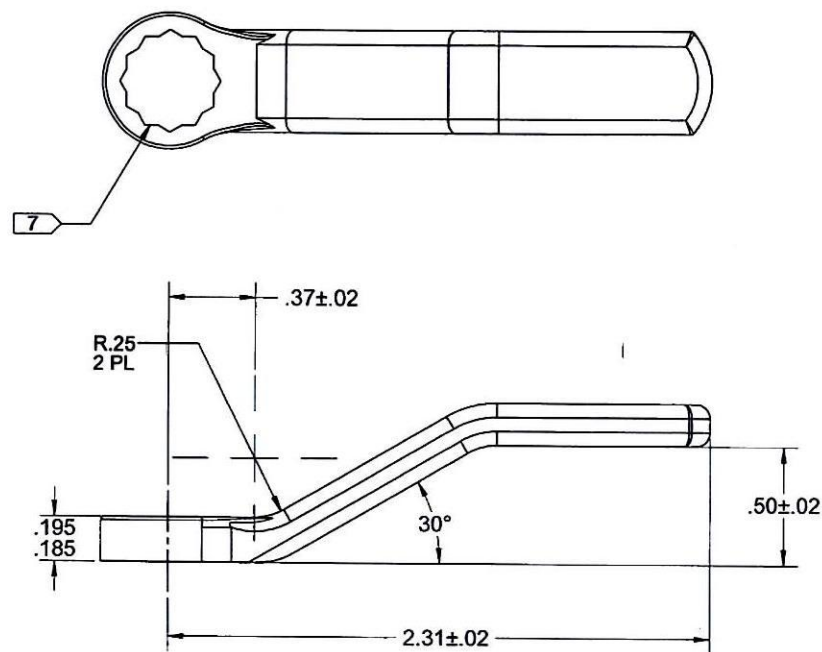
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								



NOTES:

- 1) MATERIAL: SNAP-ON XS1214 3/8"-7/16" SHORT 10° OFFSET BOX WRENCH
- 2) FINISH: N/A
- 3) HEAT TREAT: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: N/A
- 7) CHECK FOR BOX END DISTORTION WITH 3/8" HEX KEY OR BAR. IF DISTORTED, HEAT BOX END AND GENTLY WORK HEX BAR THRU. LET COOL WITH HEX BAR IN PLACE.

RB23006783-1 WRENCH, MODIFIED

DART AEROSPACE Newbury, Ontario, Canada	
TITLE WRENCH, MODIFIED	
DWG NO. RB23006783-1	REV A
DESIGN BY: SAC 19/09/2017	XXX ± .005 FRACTIONS ± 1/8
DRAWN BY: SAC 09/19/2017	XX ± .01 ANGLES ± 5°
CHECKED: VM 09/21/2017	X ± .1 SURFACES ± 1/32
MFG. APPR: DP 09/28/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
QA APPR: N/A	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: WM 10/03/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
DATE: 9/19/2017	SCALE: NTS WEIGHT: 1 SHEET 2 OF 2
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					